

Work Order ID 59442

Friday, June 04, 2010 10:28:20 AM



Page 1

Item ID: D3909-3

Accept



Setup Start



Revision ID:

Item Name: Fwd Lower Attach Arm

Stop



Start Date: 6/4/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: *10/06/04*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3909

B

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

cut 10/06/21

12

Jeaspa Bandsaw

CUT BLANK 3.455" LONG

110

0.00



HAAS 1

Memo

0.00

18 10/06/22

12

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA872 AND DWG

FOLIO REV: *AA*

DWG REV: *B*

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

28, 10/06/22

12

0

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

10/06/23

12

0

Quality Control

160

Identify as per dwg & Stock Location: 95

0.00



Packaging

Memo

0.00

10-6-23 (12x) SP

Packaging

W/O:		WORK ORDER CHANGES					
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Page 3

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/24 JF
CX 10/6/24

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Picklist Print

Friday, June 04, 2010 10:28:24 AM

Page 1

Work Order ID: 59442



Parent Item: D3909-3



Parent Item Name: Fwd Lower Attach Arm

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments: IPP REV:A NEW ISSUE 09-11-26 JLM VERIFIED BY:DD IPP
Rev:B chg blank size in seq 100 DD 10.02.10 verified JLM IPP Rev:C as per
dwg revB DD 10.04.20 verified by:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
M303B0.750X1.500		Purchased	No			100	f	0.0000	0.3333	4.210105			



303 BAR .750" X 1.500"

Batch# 114968 = 4.21" and 10/06/21

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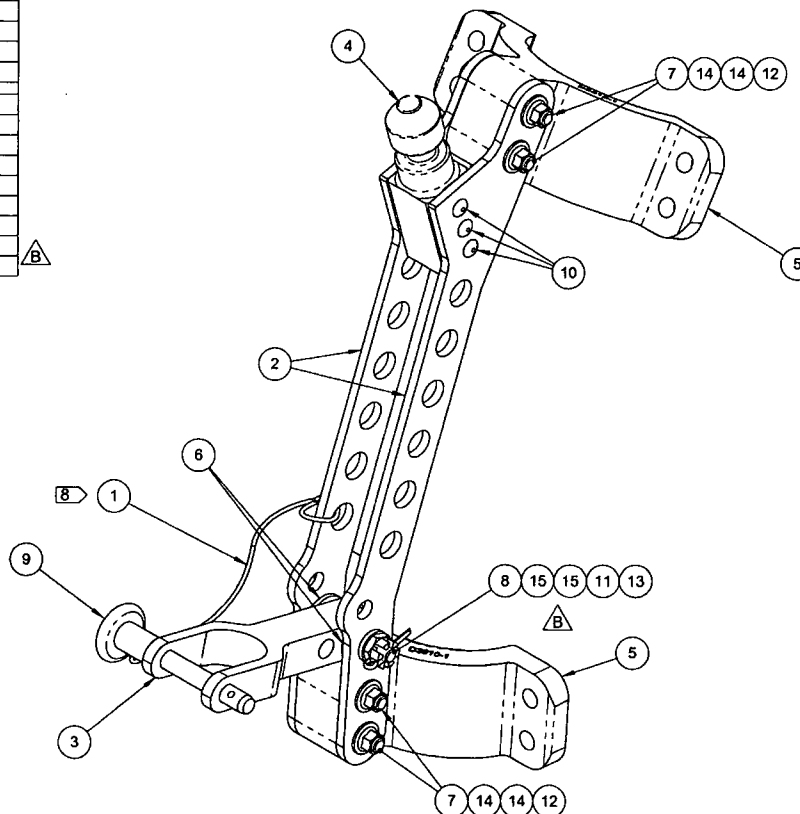
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3909-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	2	D3909-1	FWD X-TUBE LUG PLATE
3	1	D3909-3	FWD LOWER ATTACH ARM
4	1	D3909-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	2	D3917-1	WASHER
7	4	AN3C12A	BOLT
8	1	AN3C13	BOLT
9	1	MS17984-C413	PIP PIN
10	3	MS20615-4M20	RIVET
11	1	AN310C3	NUT - CASTELLATED
12	4	MS21043-3	NUT
13	1	MS24665-151	COTTER PIN
14	8	NAS1149C0332R	WASHER
15	2	NAS1149C0363R	WASHER



D3909-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.74 lbs
- 8) ATTACH TO D3909-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 591142
AD-06-04

RELEASED
2010-04-07
WP

B	BOM: ADDED ITEM 15 QTY 2 NAS1149C0363R ADDED. ITEM 14 QTY 8 WAS 10. SHT 5, D3909-5 REVISED: SECTION A-A & DIM 0.650 REMOVED. SIDE VIEW ADDED. DIM: 2.68 WAS 2.38 REF. 1.30 WAS 1.00, 0.250 WAS 0.220. R0.06 WAS R0.05. WEIGHT REVISED.		JPH	10.04.06
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED	JPH	DRAWING NO.	REV. B	
MFG. APPR.	<i>[Signature]</i>	D3909	SHEET 1 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	FWD X-TUBE LUG ASSY	NTS	
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

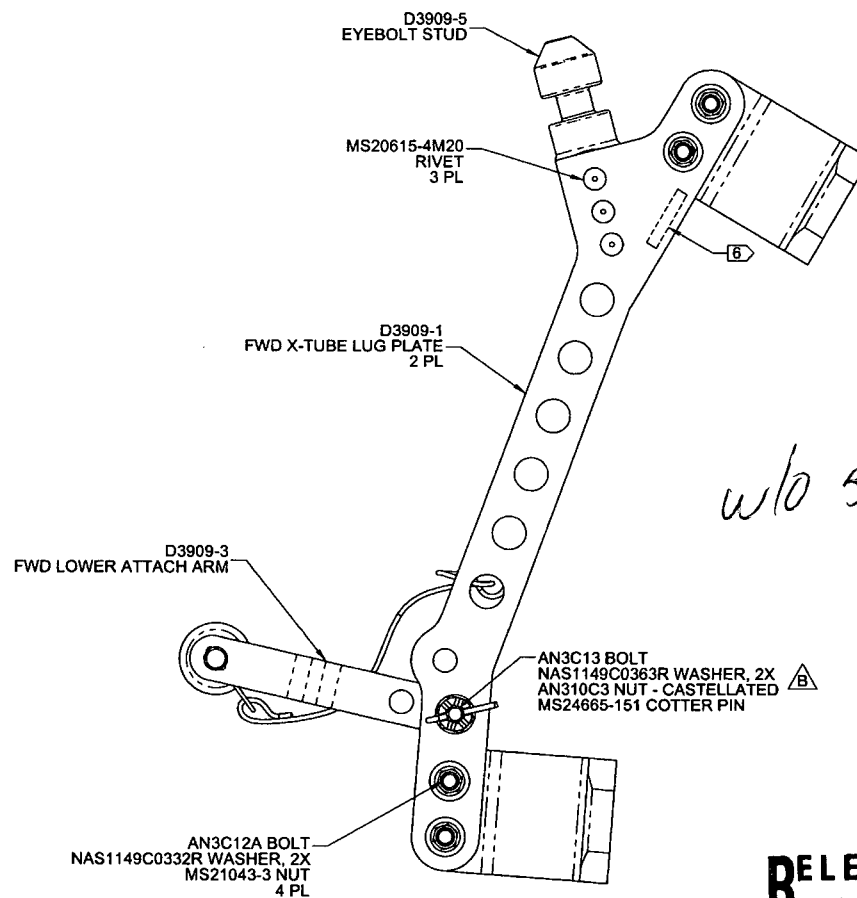
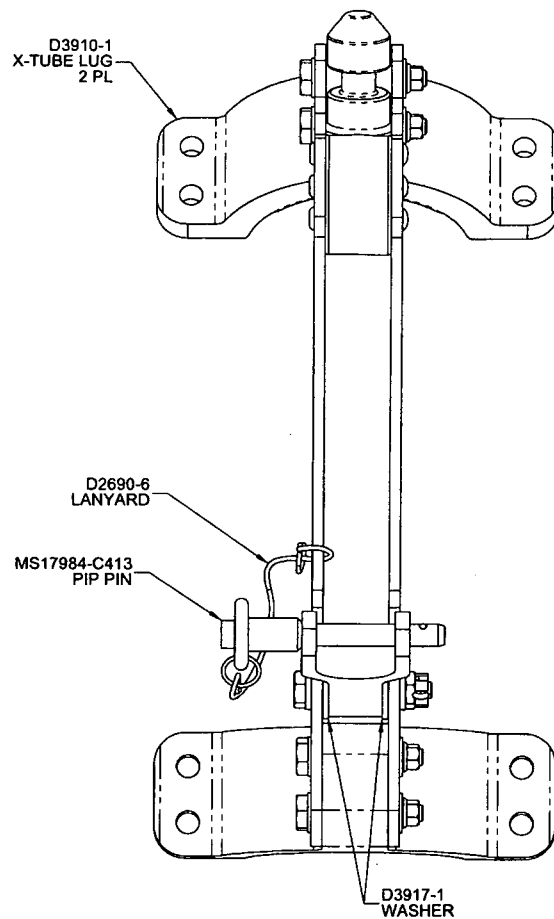
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D3909-041 FWD X-TUBE LUG ASSY

RELEASED
2010-04-07
MP

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. D3909	REV. B
MFG. APPR.	JPH		SHEET 2 OF 5
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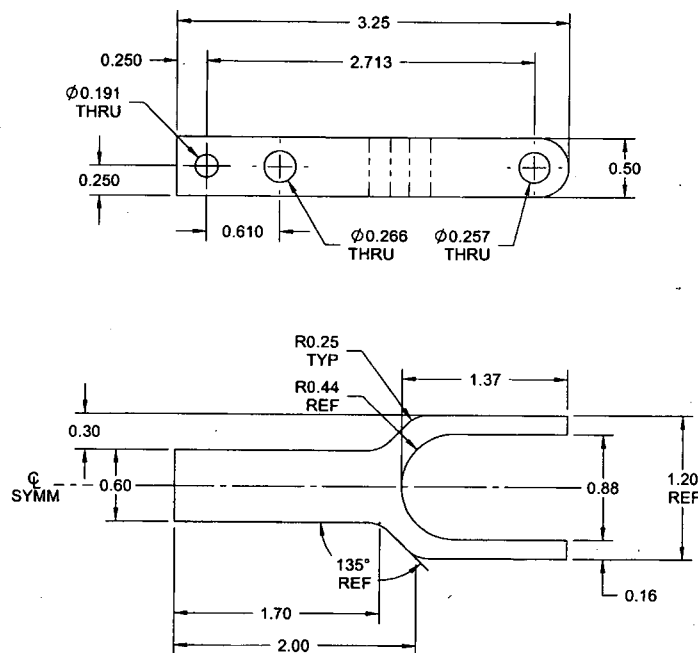
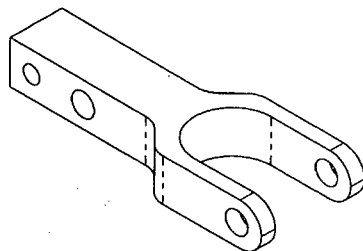
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D3909-3 FWD LOWER ATTACH ARM

W1059442

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

RELEASED
2010-04-07
WJP

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3909	SHEET 4 OF 5
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DE APPR.		FWD X-TUBE LUG ASSY	NTS
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8 7 6 5 4 3 2 1

D

C

B

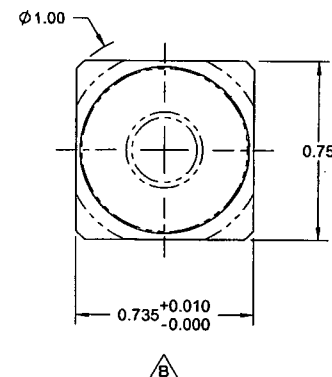
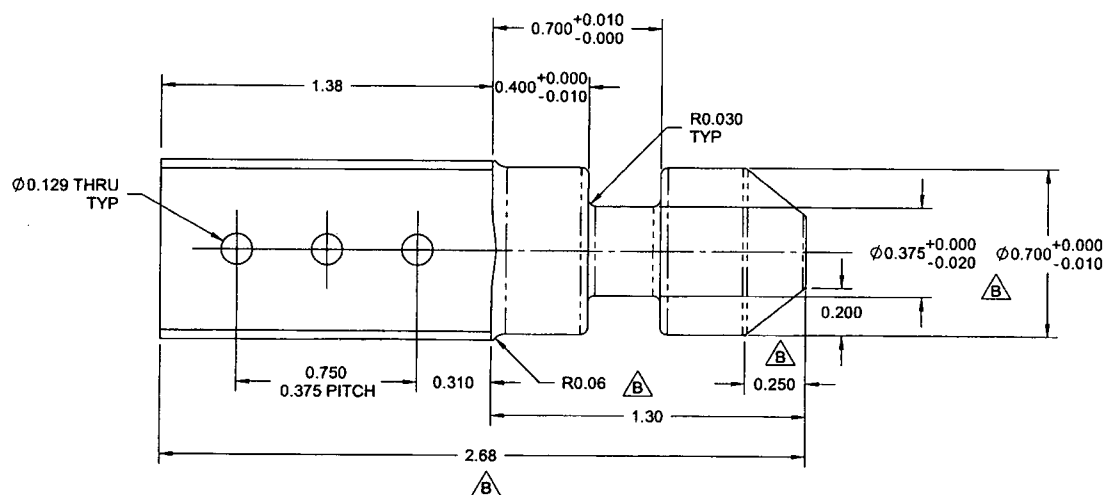
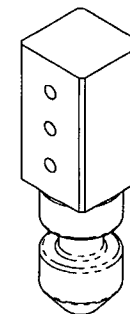
A

D

C

B

A







w/1059442

D3909-5 EYEBOLT STUD

RELEASED
2010-04-07

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.31 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3909	SHEET 5 OF 5
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DE APPR.		FWD X-TUBE LUG ASSY	NTS
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8 7 6 5 4 3 2 1

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